

**Abstract of the Disclosure (Revised)**

A die apparatus and method for performing a flashless forging operation to manufacture the toothed portion of a steering rack. The die apparatus includes first and second die members and at least one punch member, each having a forming surface shaped substantially as the obverse of a portion of the toothed portion. At least a portion of the forming surface of the first die member is shaped substantially as the obverse of the teeth of the rack. The first and second die members are moveable towards each other to a closed position, thereby partially forging the toothed portion from a blank placed in the die apparatus, and forming a substantially closed cavity defined by the forming surfaces. The punch member is adapted to move into the cavity once the die members are in the closed position, thereby completing the forging operation.